

1 Ø BE11/08/03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 70866

Thursday, June 16, 2011 12:41:27 PM



Page 2

Item ID: D3016-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Frame Assembly

Start Date: 6/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

J u/08/04

10

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

Install paint screws on fitting ends
START TIME: *10:15am*
OVEN TEMPERATURE: *320°F*
FINISH TIME: *10:45pm*

1 0 11 u/08/04

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

H P m u/08/04

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NOTE: Date & initial all entries

Work Order ID 70866



Page 3

Thursday, June 16, 2011 12:41:27 PM

Item ID: D3016-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Frame Assembly

Start Date: 6/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

150

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

w/o

0.00

70903

ES 11/08/10 (1)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/10

11-08-10 (1)

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NOTE: Date & initial all entries

Thursday, June 16, 2011 12:41:24 PM

[illegible][illegible]**Required Date:** 6/28/2011

Required Qty: 1.00

Comments: IPP A001.09.19 New issue EC IPP RevB: as per revB DD verified by:JLM

[illegible]

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 16, 2011 12:41:24 PM

Page 2

Work Order ID: 70866

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 6/28/2011

Required Date: 6/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3016-13

Manufactured No

100

Each

10.0000

2

2



Bracket



EL 11-8-7

Location

Loc Qty

Loc Code

WA

10

70015

10

2

D3016-15

Manufactured No

100

Each

2.0000

2

2



Gusset



EL 11-8-3

Location

Loc Qty

Loc Code

WA019

2

68735

2

2

D3020-1

Manufactured No

100

Each

1.0000

4

4



Fitting



EL 11-6-20

Location

Loc Qty

Loc Code

WA

1

36713

1

1

70873

3

3

Thursday, June 16, 2011 12:41:24 PM

Shop Packet Print

Page 2

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NOTE: Date & initial all entries



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|---------------------|-----------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D3016 | REV. A SHEET 1 OF 3 |
| DATE 01.05.18 | | TITLE SEAT FRAME ASSEMBLY | SCALE NTS |
| A | 01.05.18 | NEW ISSUE | |

| QTY | PART NUMBER | DESCRIPTION | MATERIAL |
|-----|-------------|---------------------|--|
| X | D3016-041 | SEAT FRAME ASSEMBLY | N/A |
| 1 | D3016-1 | TUBE | AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049) |
| 2 | D3016-3 | TUBE | AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049) |
| 1 | D3016-5 | TUBE | AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049) |
| 2 | D3016-7 | TUBE | AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049) |
| 1 | D3016-9 | SADDLE | AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120) |
| 1 | D3016-11 | SADDLE | AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120) |
| 1 | D3016-13 | BRACKET | AISI 4130N SHEET, 18 GAUGE (M4130N-S049) |
| 1 | D3016-15 | GUSSET | AISI 4130N SHEET, 18 GAUGE (M4130N-S049) |
| 1 | D3016-17 | GUSSET | AISI 4130N SHEET, 18 GAUGE (M4130N-S049) |
| 2 | D3020-1 | FITTING | N/A |

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O 70866

DEO ATTACHED

RELEASED
01-05-30 *#*

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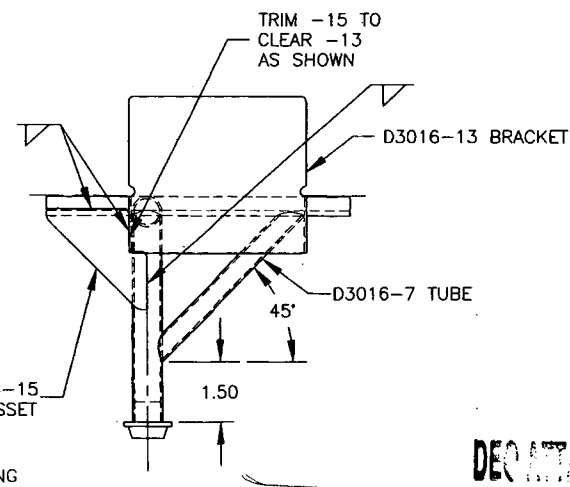
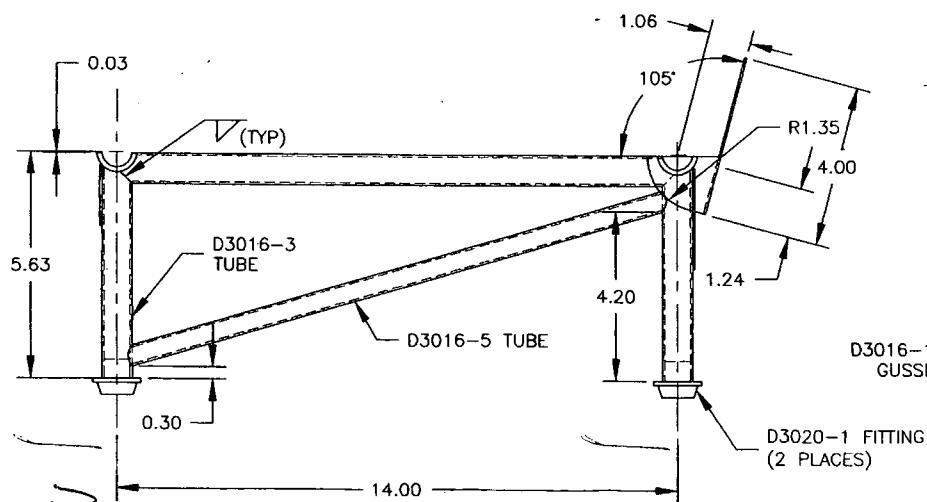
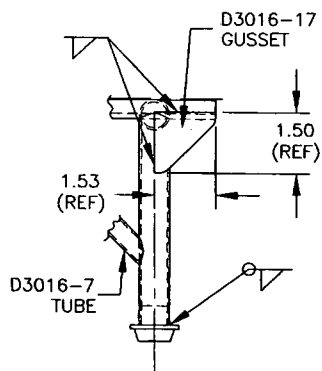
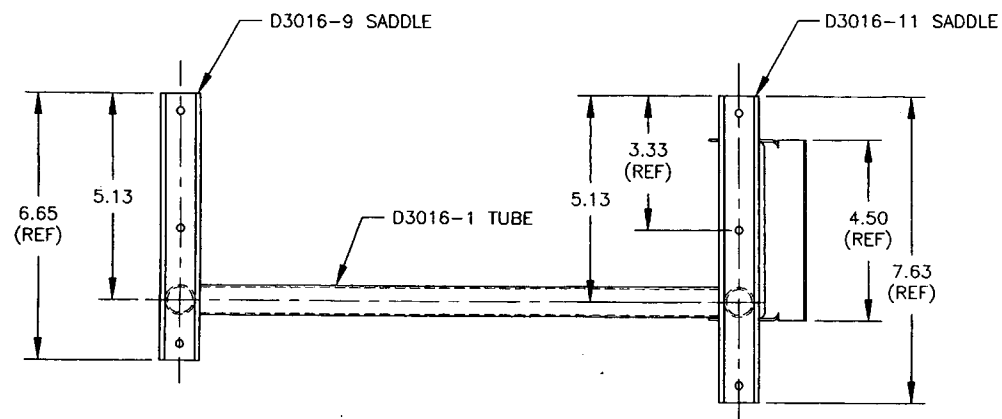
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NOTE: Date & initial all entries

D3016-041 SEAT FRAME ASSEMBLY



70866

DEC ATTACHED

RELEASED
01.05.30

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|--|--|---------------------|-----------------------|-------------|--|--------------|
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| | | DATE 01.05.18 | | | TITLE SEAT FRAME ASSEMBLY | SHEET 2 OF 3 |
| | | | | | | SCALE |
| | | | | | | 1:3 |

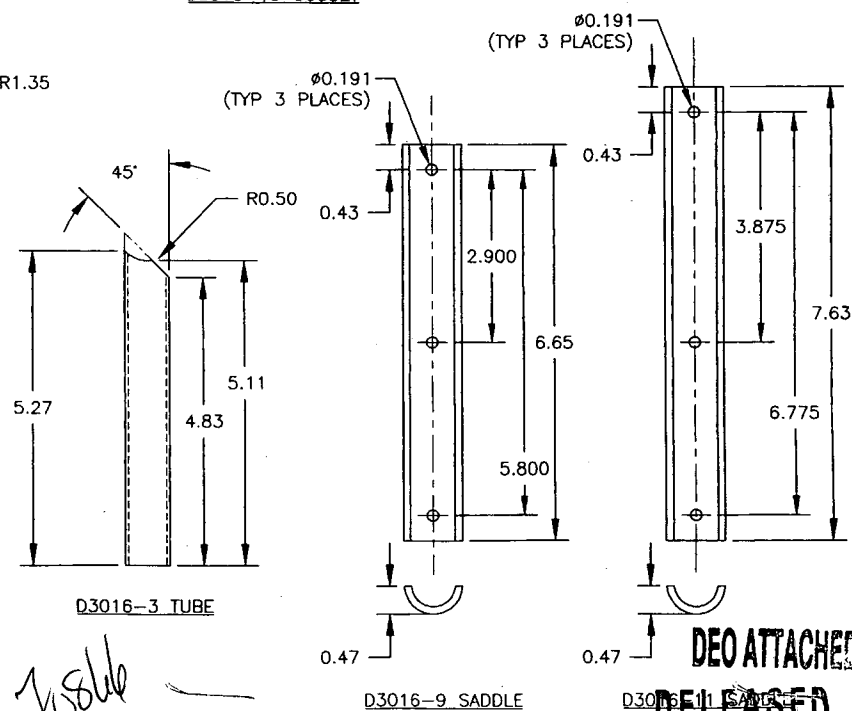
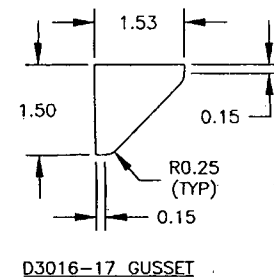
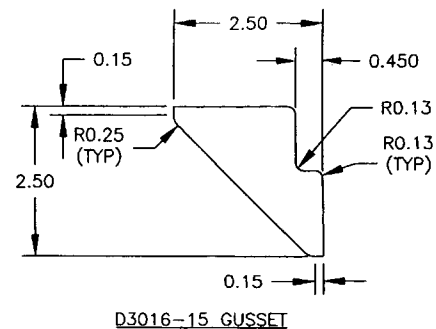
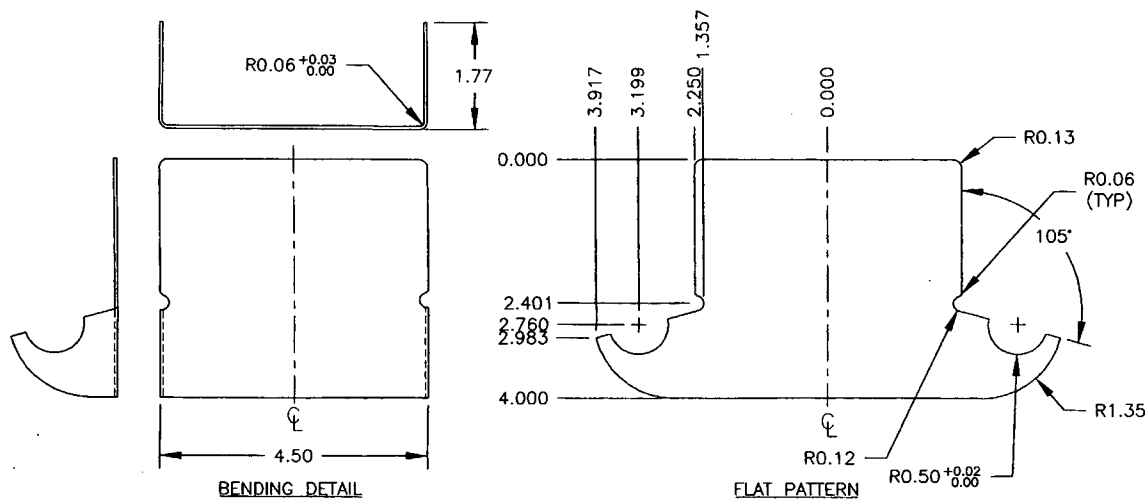
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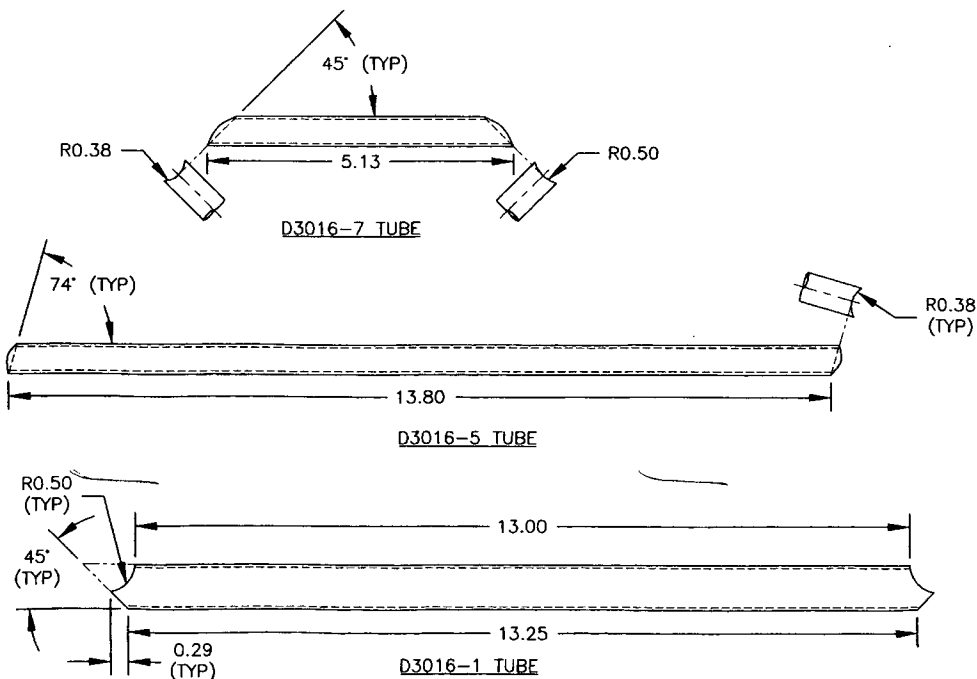
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NOTE: Date & initial all entries



7066

DEO ATTACHED
RELEASED
9.05.30



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|---------|----------|----------|---------------------|-------------|--|
| DESIGN | CP | DRAWN BY | CP | DART | DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA |
| CHECKED | # | APPROVED | # | DRAWING NO. | D3016 |
| DATE | 01.05.18 | TITLE | SEAT FRAME ASSEMBLY | REV. A | SHEET 3 OF 3 |
| | | | | SCALE | 1:2 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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|----------------------|------------------------------|-------------------------|---|-------------------------|---------------------------|--------------|
| DRAWING NO. D3016 | TITLE SEAT FRAME ASSEMBLY | REV. A | DART AEROSPACE LTD ENGINEERING ORDER | D.E.O. NO. D3016-A-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>1</i> | CHECKED <i>UP</i> | MFG. APPR. <i>RE</i> | APPROVED <i>MAP</i> | DE APPR. <i>#</i> | | |
| DATE 10.01.29 | DATE 10.01.29 | DATE 10.01.29 | DATE 10.01.29 | DATE 10.01.29 | | |

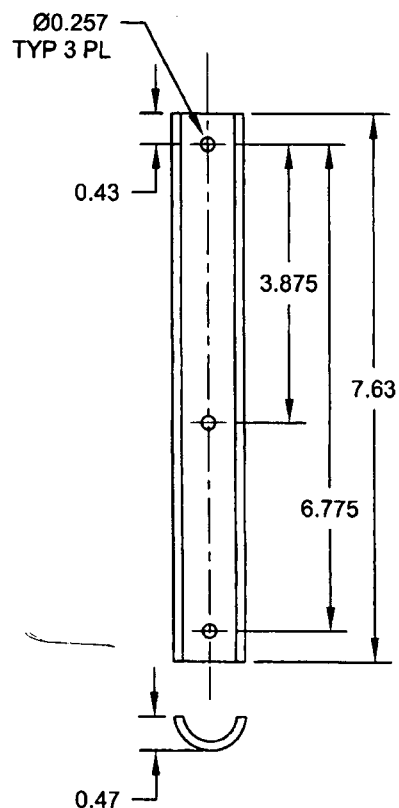
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

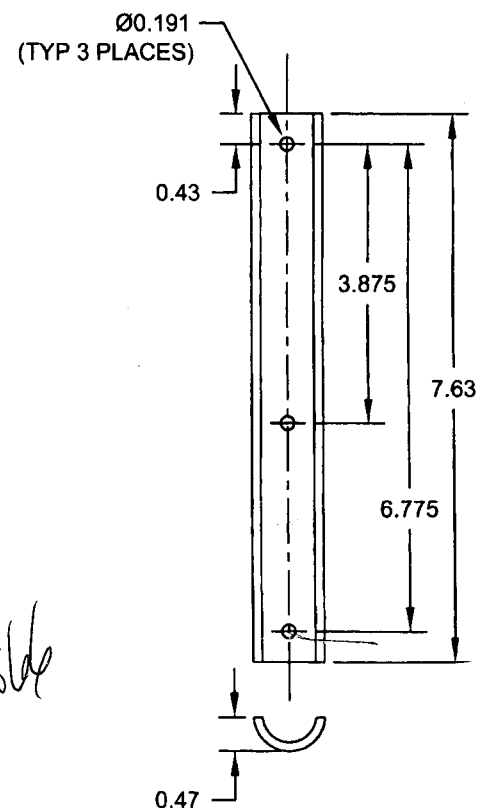
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

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